

# Work Order ID 82628

April-04-12 10:48:54 AM

**\*82628\***

Page 1

Item ID: D4306-044 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib Assembly, RH  
 Start Date: 04/04/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 30/04/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: MLT Date: 12/04/04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4306	C								

100 Weld per dwg A/R S.S. rod Batch: M121602 0.00

**\*100\***

Large Fab

Large Fab

## Memo

1- Cut tube 52"

2- Bend tube with manuel pipe bender as per DT9567

\*\*\* Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*

3- Trim access tube material to finish size and cut notch as per dwg D4306-4

4- Drill and chamfer holes as per dwg D4306-4 using DT9710

5- weld bushing as per dwg D4306

6- grind welds flush

① SAD 12-02-19

SD/CC 12-7-20

110

QC6- Inspect dimensions to drawing

0.00

**\*110\***

QC

Quality Control

## Memo

0.00

1/x 12-7-23 **DAS 24**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82628

April-04-12 10:48:54 AM

**\*82628\***

Page 2

Item ID: D4306-044  
Revision ID:  
Item Name: Rib Assembly, RH

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

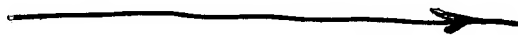


Start Date: 04/04/2012 Start Qty: 2.00 **\*2\***  
Required Date: 30/04/2012 Req'd Qty: 2.00 **\*2\***


Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds <b>QC 9</b>  Memo	0.00 0.00				1x	0	<b>DAS 24 9-88</b> 12.7.23	
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <b>WA</b> Memo	0.00 0.00				1x		<b>DAS 24 9-88</b> 12.7.23	
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/7/24  MLJ 12/07/23

W/O: 82628		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-7-23	120	Change to QC9	CPC				

Part No: D4306-044 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April-04-12 10:48:58 AM

Page 1

Work Order ID: 82628

\*82628\*

Parent Item: D4306-044

\*D4306-044\*

Parent Item Name: Rib Assembly, RH

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC  
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	231.0000	4	8			
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\*D3759-1\*

Bushing

\*\*

CC 12-7-20

## Location

## Loc Qty

## Loc Code

WA

203

B-83464 →

(4X)

79213

203

WA005

28

66489

1

74783

27

M304TS0.750W.049

Purchased

No

100

f

556.4351

4.166

8.770526

4.3853

\*M304TS0 750W 049\*

304 SQ Tube .75x.75x.049W

\*\*

SAP

12-07-20

## Location

## Loc Qty

## Loc Code

MAT018

248.3105959

117775

93.6739

118472

47.1990839

118880

0.2736

119147

76.4906

119643

17.1154

120494

13.5580119

MAT034

285.197927

117337

1.8507

121087

283.347227

WA035

22.92654

118184

22.92654

11121898

4.3853

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

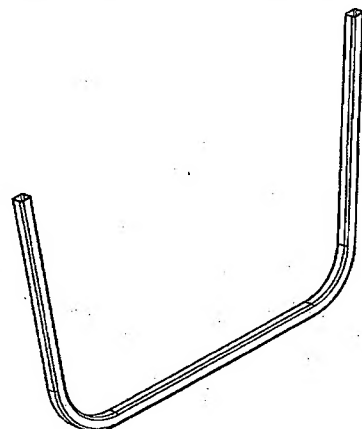
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

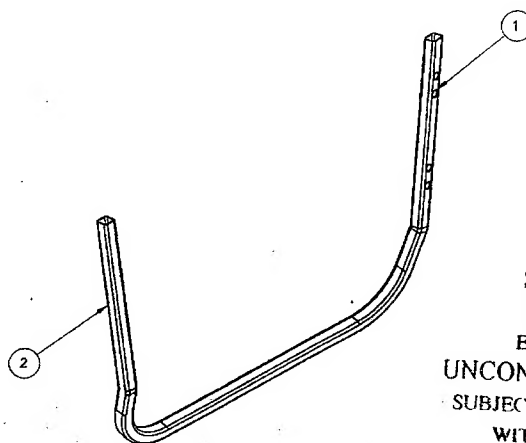
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

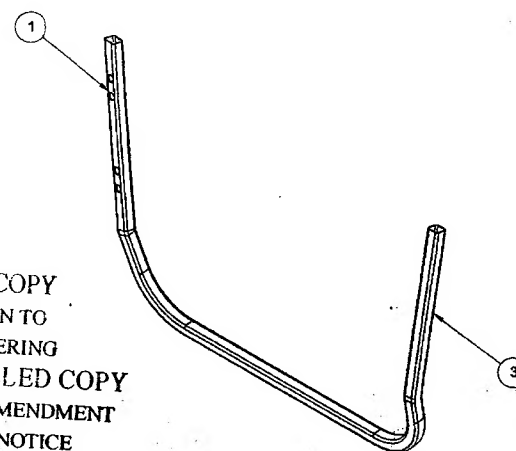
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	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



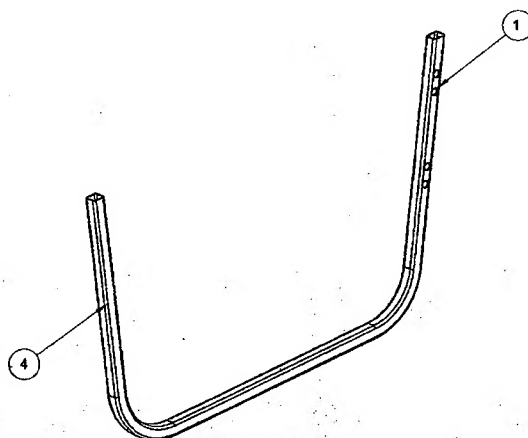
**D4306-1 RIB**



**D4306-043 RIB ASSY, LH**



**D4306-044 RIB ASSY, RH**



**D4306-045 RIB ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 82628 MJS  
12/04/04

RELEASED  
2011-03-18

C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B6-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

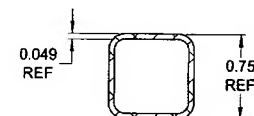
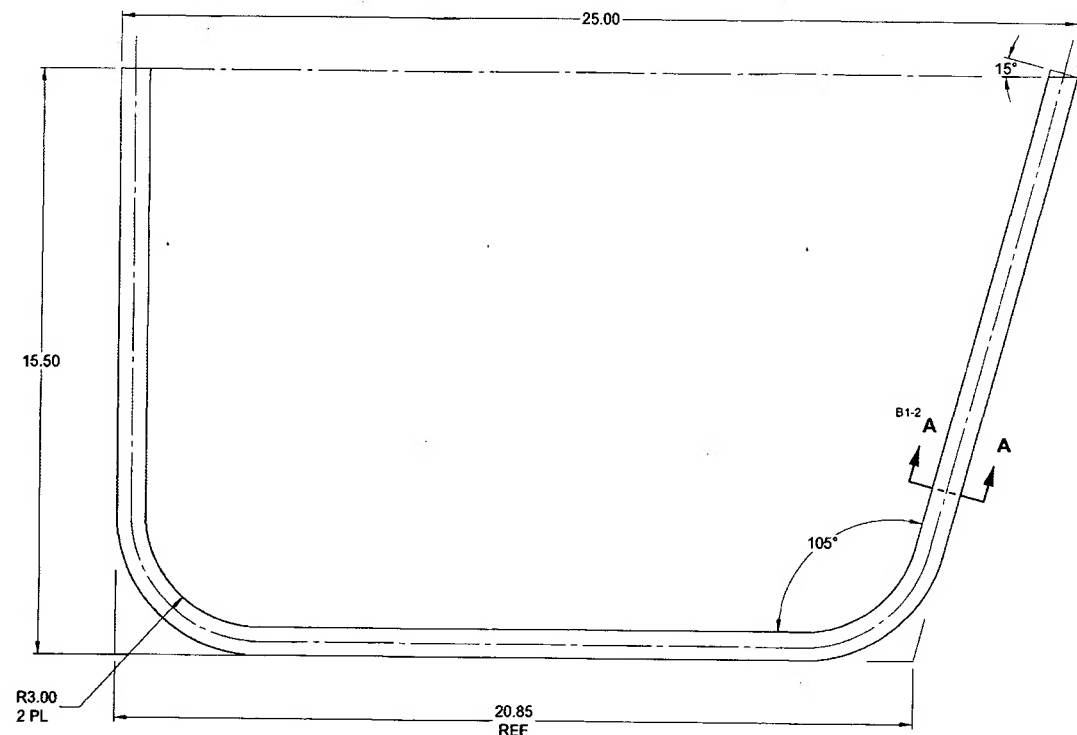
DRAWING NO. **D4306** REV. C  
TITLE **RIB** SCALE **NTS**

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02628



SECTION A-A  
B4-2

8 D4306-1 RIB

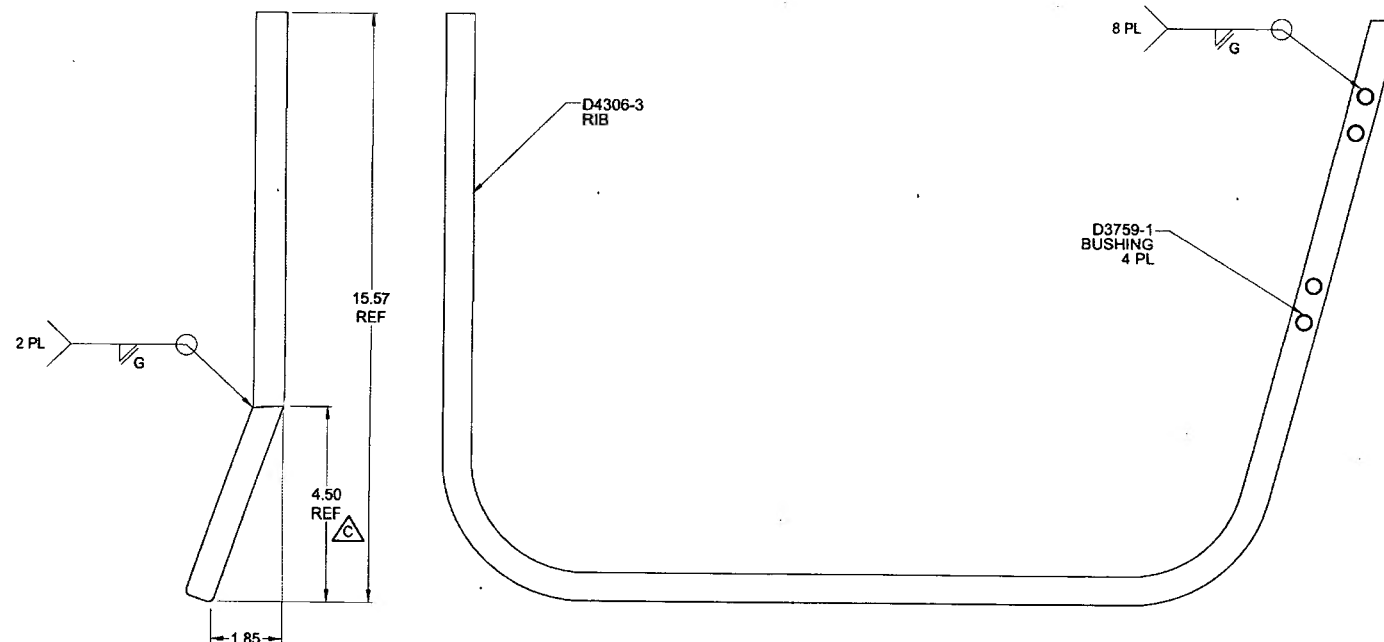
RELEASED  
2011-02-24  
WAD

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4306	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
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82628



**D4306-043 RIB ASSY, LH**

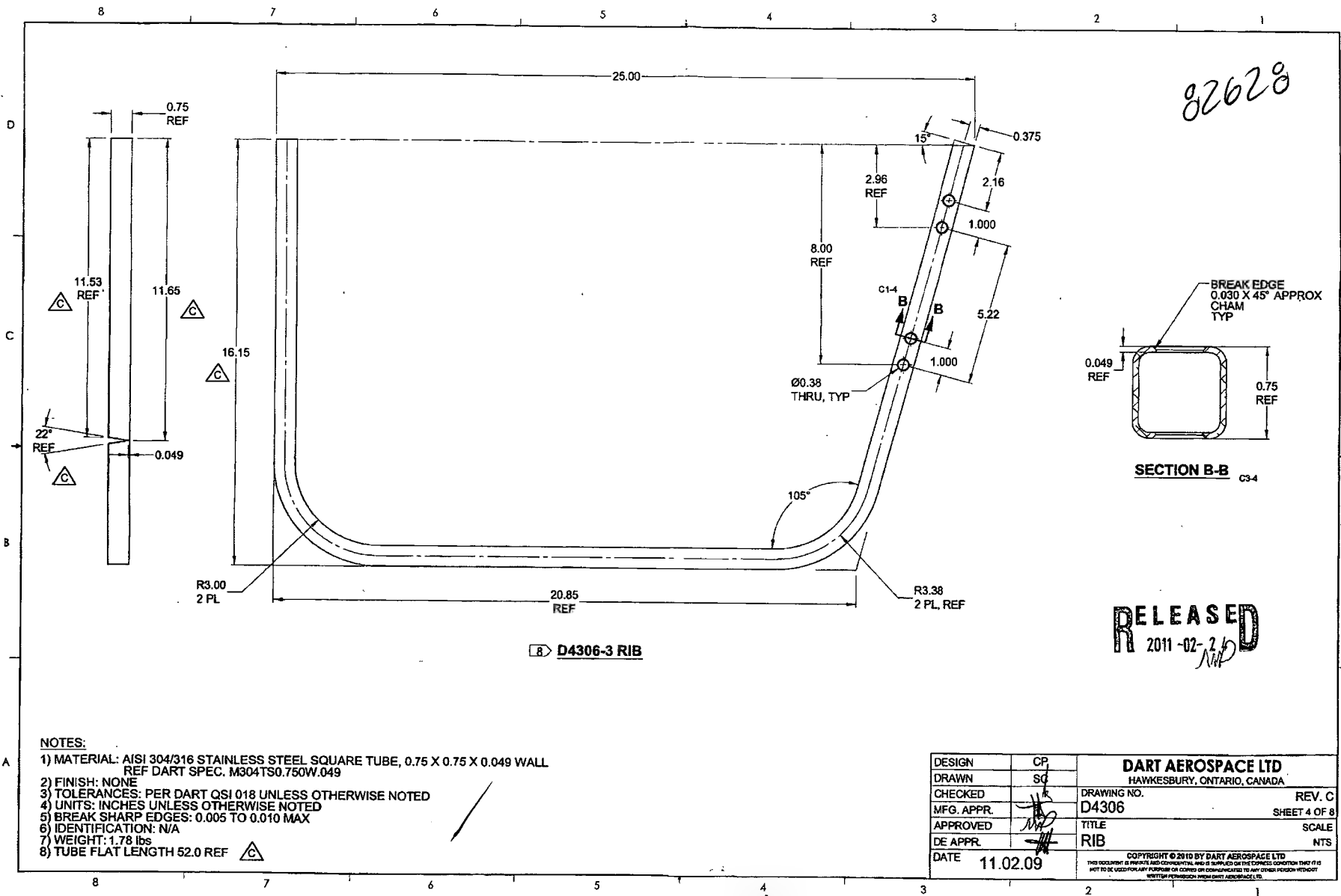
RELEASED  
2011-02-24

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	AS	DRAWING NO. <b>D4306</b>	REV. C
MFG. APPR.	AS		SHEET 3 OF 8
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SECTION B-B C3-4

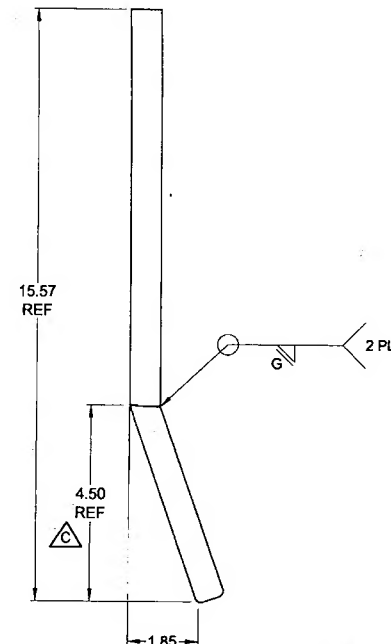
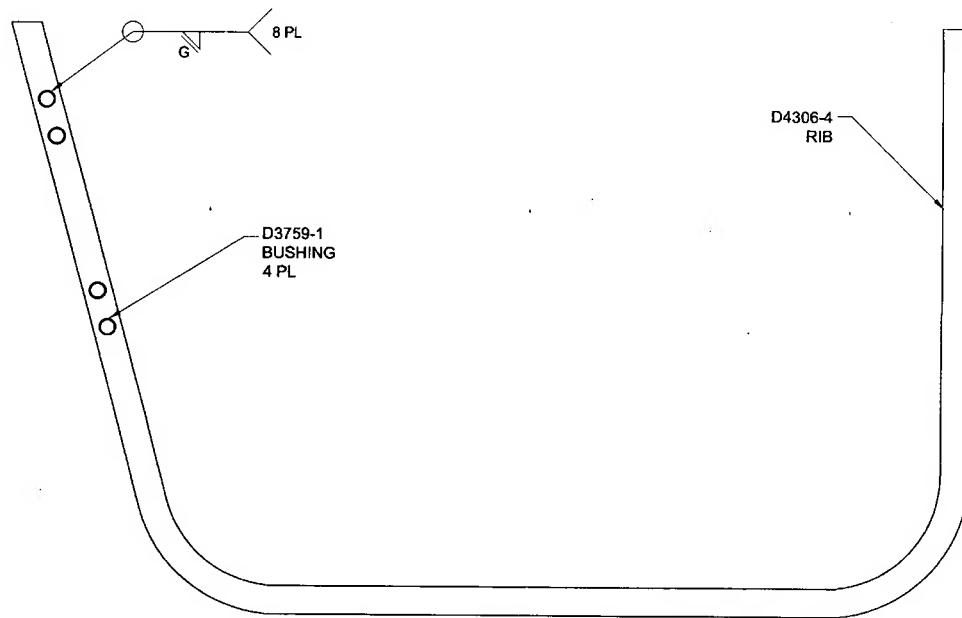
RELEASED  
2011-02-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4306	SHEET 4 OF 8
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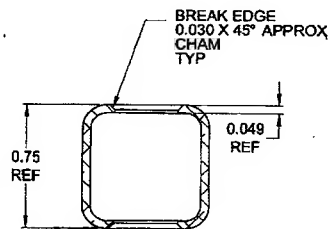
**D4306-044 RIB ASSY, RH**

**RELEASED**  
2011-02-24  
WJ

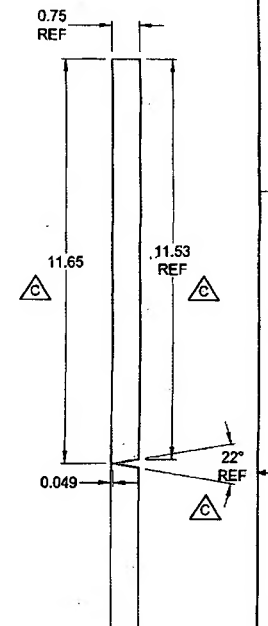
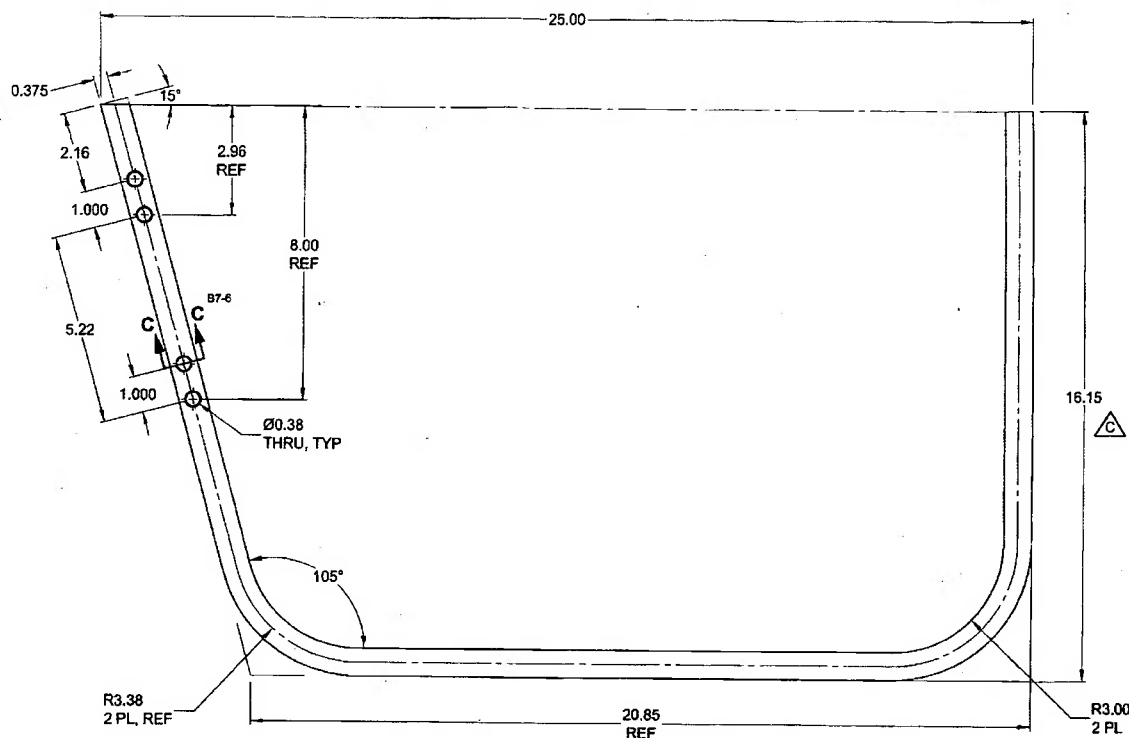
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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DRAWN	SC		
CHECKED	LS	DRAWING NO.	REV. C
MFG. APPR.	JS	<b>D4306</b>	SHEET 5 OF 8
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DE APPR.	WJ	<b>RIB</b>	NTS
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**SECTION C-C**  
C6-6



**D4306-4 RIB**

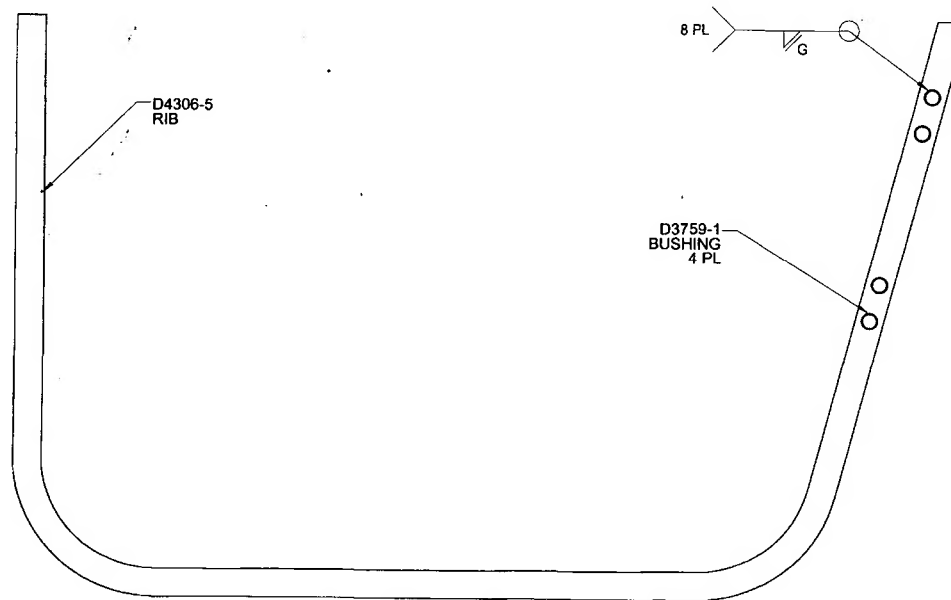
**RELEASED**  
2011-02-20

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4306</b>	SHEET 6 OF 8
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DE APPR.		<b>RIB</b>	NTS
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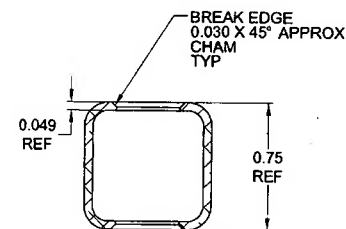
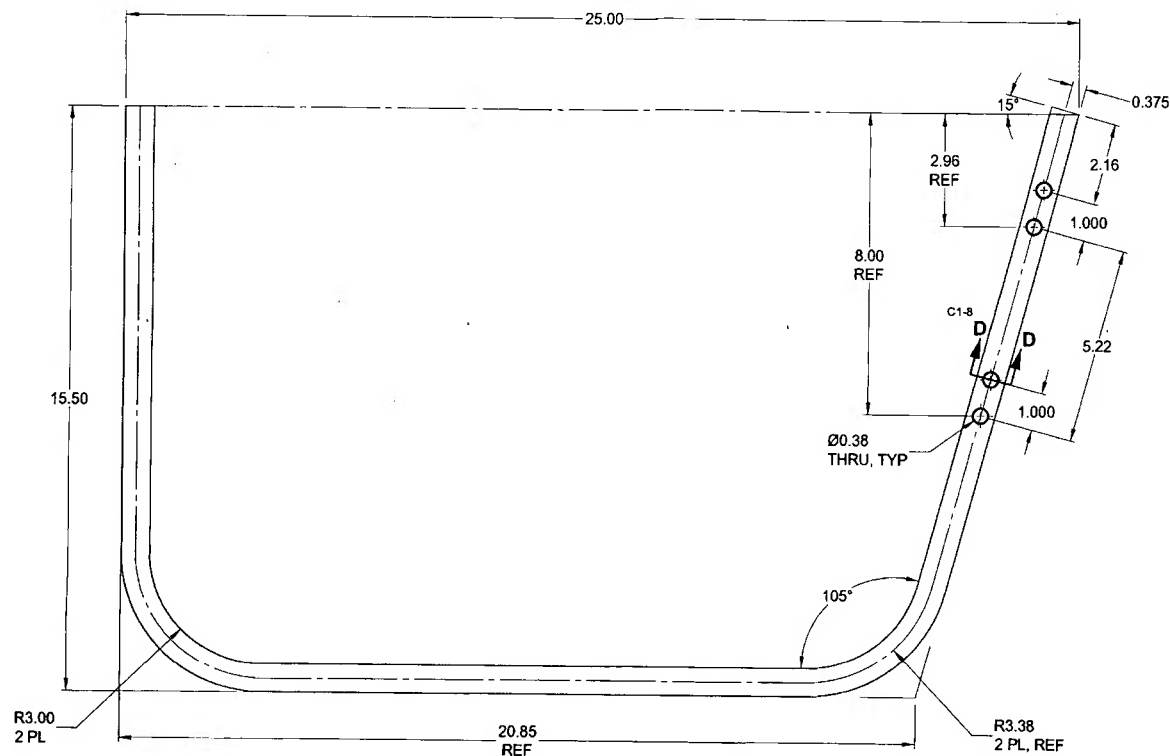
**D4306-045 RIB ASSY**

**RELEASED**  
2011-02-24  
MAD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	MD	DRAWING NO.	REV. C
MFG. APPR.	MD	D4306	SHEET 7 OF 8
APPROVED	MD	TITLE	SCALE
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SECTION D-D C3-8

RELEASED  
2011-02-24

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	LS	DRAWING NO.	REV. C
MFG. APPR.	LS	<b>D4306</b>	SHEET 8 OF 8
APPROVED	ANF	TITLE	SCALE
DE APPR.	ANF	<b>RIB</b>	NTS
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